



Dart Aerospace Ltd.
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Canada

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D3275-1

Job Sheet 197858



Part No: D3275-1

Job Qty: 120 pcs

Part Name: Cross Bolt Spacer

126



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/18/19

Job Tracking No:

Due Date: 8/9/19

July 22
ASAP

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A1 IPP Rev:A 04.10.19 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	120 pcs	8/9/19	8/9/19	0.02	2.30	Hardinge - 1		BM JULY 19/19
120	QC 8	120 pcs	8/9/19	8/9/19	0.00	0.00	QC 8 - 12		JUL 19/07/20
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
160	Packaging 3-1 - Stock - B4B	120 pcs	8/9/19	8/9/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

QC2 DAS 73 9-89
19-07-19



Container No: S199330



Part: D3275-1

Job No: 197858

Serial No/Batch: S199330

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 07/19/19

Plex 7/18/19 7:13 AM Dart.lajeunesse.marie

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BE
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	120 pcs	8/9/19	0.00 0.00	QC 21 - SA - 21	DAS JUL 22 2019
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-55

Part Op **100** - (Hardinge) 1-Turn as per Folio FA469 and Dwg D3275
 Descriptions: **120** - (QC8- Inspect parts - second check)
160 - (Identify as per dwg & Stock Location 16001) ***STOCK IN SKIDTUBE CELL***
170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.3125W.058	Aluminum Tube .3125 X .058W	31.9920 ft (.2666 ea)	100-Hardinge - 1	S/45220

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6T0.3125W.058	32	106	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crossbolt Spacer	3.180inches $\pm$ 0.010	3.190 3.170	3.181	
2	Crossbolt Spacer	0.025inches + 0.005 - 0.000	0.030 0.025	0.029	
3	Crossbolt Spacer	45.00Degrees $\pm$ 0.01	45.01 44.99	45.0	
4	Crossbolt Spacer	0.313inches + 0.010 - 0.005	0.323 0.308	0.313	
5	Crossbolt Spacer	0.0580inches + 0.0025 - 0.0000	0.0605 0.0580	0.060	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					